

# DBC

建議機器轉速 RPM = 10000 (min<sup>-1</sup>) 以下  
 < Be used under the machine of RPM = 10000 (min<sup>-1</sup>) >

## 切削條件表 MILLING CONDITIONS

被切削材 Work Material		鋁合金 : Aluminum Alloy 5052 / 6061 / 7075					
冷卻方式 Coolant Type		溼式切削 Wet coolant					
型號 Type NO.	刀具伸長量 Extension Length(mm)	切削速度 Cutting Speed(m/min)	迴轉速度 Speed (min <sup>-1</sup> )	進給速度 Feed (mm/min)	加工深度 (Aa) Depth of Cut	加工寬度 (Ap) Width of Cut	加工方式 Milling Type
DBC0102	10	30	9500~10000	600~1000	0.08~0.11	0.15~0.18	3D 銑 (3D milling)
DBC0102	10	30	9500~10000	1000~1400	0.03~0.05	0.05~0.08	3D 銑 (3D milling)
DBC0152	12	45	9500~10000	800~1200	0.08~0.11	0.15~0.18	3D 銑 (3D milling)
DBC0152	12	45	9500~10000	1200~1600	0.03~0.05	0.05~0.08	3D 銑 (3D milling)
DBC0202	12	60	9000~9500	1000~1400	0.1~0.13	0.2~0.25	3D 銑 (3D milling)
DBC0202	12	60	9000~9500	1600~2000	0.04~0.06	0.06~0.1	3D 銑 (3D milling)
DBC0302	14	85	9000~9500	1100~1500	0.12~0.15	0.23~0.28	3D 銑 (3D milling)
DBC0302	14	85	9000~9500	1800~2200	0.05~0.07	0.8~0.12	3D 銑 (3D milling)
DBC0402	14	115	9000~9500	1400~1800	0.15~0.18	0.3~0.4	3D 銑 (3D milling)
DBC0402	14	115	9000~9500	1800~2200	0.06~0.08	0.1~0.13	3D 銑 (3D milling)
DBC0602	20	160	8500~9000	1400~1800	0.2~0.25	0.4~0.5	3D 銑 (3D milling)
DBC0602	20	170	9000~9500	1800~2200	0.08~0.1	0.12~0.15	3D 銑 (3D milling)
DBC0802	25	200	8000~8500	1600~2000	0.25~0.3	0.5~0.6	3D 銑 (3D milling)
DBC0802	25	230	9000~9500	2000~2400	0.08~0.13	0.15~0.2	3D 銑 (3D milling)
DBC1002	35	255	8000~8500	1600~2000	0.3~0.35	0.7~0.8	3D 銑 (3D milling)
DBC1002	35	285	9000~9500	2000~2400	0.1~0.15	0.18~0.23	3D 銑 (3D milling)
DBC1202	40	290	7700~8200	1600~2000	0.4~0.45	0.8~1	3D 銑 (3D milling)
DBC1202	40	290	7700~8200	2000~2400	0.13~0.16	0.2~0.25	3D 銑 (3D milling)

# DBC

建議機器轉速 RPM = 20000 (min<sup>-1</sup>) 以下  
 < Be used under the machine of RPM = 20000 (min<sup>-1</sup>) >

## 切削條件表 MILLING CONDITIONS

被切削材 Work Material		鋁合金 : Aluminum Alloy 5052 / 6061 / 7075					
冷卻方式 Coolant Type		溼式切削 Wet coolant					
型號 Type NO.	刀具伸長量 Extension Length(mm)	切削速度 Cutting Speed(m/min)	迴轉速度 Speed (min <sup>-1</sup> )	進給速度 Feed (mm/min)	加工深度 (Aa) Depth of Cut	加工寬度 (Ap) Width of Cut	加工方式 Milling Type
DBC0102	10	65	19000~20000	800~1200	0.08~0.11	0.15~0.18	3D 銑 (3D milling)
DBC0102	10	65	19000~20000	1200~1600	0.03~0.05	0.05~0.08	3D 銑 (3D milling)
DBC0152	12	90	18000~19000	1000~1400	0.08~0.11	0.15~0.18	3D 銑 (3D milling)
DBC0152	12	90	18000~19000	1400~1800	0.03~0.05	0.05~0.08	3D 銑 (3D milling)
DBC0202	12	120	18000~19000	1200~1600	0.1~0.13	0.2~0.25	3D 銑 (3D milling)
DBC0202	12	120	18000~19000	1800~2200	0.04~0.06	0.06~0.1	3D 銑 (3D milling)
DBC0302	14	160	17000~18000	1300~1700	0.12~0.15	0.23~0.28	3D 銑 (3D milling)
DBC0302	14	160	17000~18000	2000~2400	0.05~0.07	0.8~0.12	3D 銑 (3D milling)
DBC0402	14	200	16000~17000	1600~2000	0.15~0.18	0.3~0.4	3D 銑 (3D milling)
DBC0402	14	200	16000~17000	2000~2400	0.06~0.08	0.1~0.13	3D 銑 (3D milling)
DBC0602	20	285	15000~16000	1600~2000	0.2~0.25	0.4~0.5	3D 銑 (3D milling)
DBC0602	20	285	15000~16000	2000~2400	0.08~0.1	0.12~0.15	3D 銑 (3D milling)
DBC0802	25	330	13000~14000	2000~2400	0.25~0.3	0.5~0.6	3D 銑 (3D milling)
DBC0802	25	330	13000~14000	2400~2800	0.08~0.13	0.15~0.2	3D 銑 (3D milling)
DBC1002	35	380	12000~13000	2000~2400	0.3~0.35	0.7~0.8	3D 銑 (3D milling)
DBC1002	35	380	12000~13000	2400~2800	0.1~0.15	0.18~0.23	3D 銑 (3D milling)
DBC1202	40	415	11000~12000	2000~2400	0.4~0.45	0.8~1	3D 銑 (3D milling)
DBC1202	40	415	11000~12000	2400~2800	0.13~0.16	0.2~0.25	3D 銑 (3D milling)